

METHOD OF INCREASING THE GAS TRANSMISSION RATE OF A FILMBACKGROUND OF THE INVENTION

5           The present invention relates to packaging films, and more particularly to a method of increasing the gas transmission rate of a packaging film.

          It is sometimes useful to package a product within a packaging atmosphere that is different from the composition (e.g., oxygen content) and/or condition (e.g., pressure) of ambient air. For example, fresh red meat may be packaged within a modified atmosphere to extend the shelf life of the packaged fresh red meat. The modified atmosphere may be one having a low amount of oxygen, such as less than about 0.5 volume % oxygen or less than about 0.05 volume % oxygen.

10           However, fresh red meat packaged in a low-oxygen atmosphere typically has a purple color that may displease retail customers. Therefore, it may be desirable to allow the composition and/or conditions of the modified atmosphere within the package to approach that of ambient air after the package arrives at a supermarket or other retail outlet. For example, oxygen from ambient air may be allowed to reach the interior of the package in order to cause the meat to "bloom" to a red color suitable for retail display.

15           Several package designs provide for transportation of a food product in a low-oxygen environment, and for the quick introduction of oxygen to allow the food product to bloom at the retail outlet before display to the consumer. See, for example, U.S. Patents 5,591,468; 5,686,126; 5,779,050; 5,919,547; and 6,032,800; each of which is incorporated herein in its entirety by reference.

20           Such packages may include a peelable laminate, for example a laminate that may be separated (e.g., hand peeled) into a relatively oxygen-permeable film and a relatively oxygen-impermeable film. Such a laminate may be sealed to a support member -- such as a tray supporting a fresh red meat product -- to form a low-oxygen modified-atmosphere, closed package having a relatively low oxygen-transmission rate to maintain the internal modified atmosphere in its modified condition. At the retail outlet, the relatively oxygen-impermeable film may be peeled from the laminate leaving the relatively oxygen-permeable film sealed to the

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tray – resulting in a closed package having a relatively high oxygen transmission rate through the film, so that oxygen relatively quickly transfers through the film to bloom the meat to a bright red. However, a drawback to such systems is the requirement for peeling the relatively oxygen-impermeable film from the laminate.

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#### SUMMARY OF THE INVENTION

The present invention addresses one or more of the aforementioned problems. One embodiment is a method of increasing the gas transmission rate of a packaging film. A packaging film is provided, which comprises at least about 0.001 weight % of single-walled carbon nanotube material based on the weight of the film. The packaging film is exposed to an amount of radiation energy effective to increase the oxygen transmission rate of the packaging film by at least about 100 cubic centimeters (at standard temperature and pressure) per square meter per day per 1 atmosphere of oxygen pressure differential measured at 0% relative humidity and 23°C.

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Another embodiment of the invention is a packaging film comprising at least one layer comprising 100 weight parts of oxygen barrier polymer selected from one or more of ethylene/vinyl alcohol copolymer, polyvinyl alcohol, vinylidene chloride polymer, polyalkylene carbonate, polyester, polyacrylonitrile, and polyamide. The at least one layer also comprises at least about 0.001 weight parts of single-walled carbon nanotube material per 100 weight parts oxygen barrier polymer.

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Still another embodiment of the invention is a packaging film comprising at least one layer. One or more discontinuous regions are supported by the at least one layer of the film. The one or more discontinuous regions comprise at least about 0.001 weight % of single-walled carbon nanotube material based on the weight of the film.

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These and other objects, advantages, and features of the invention may be more readily understood and appreciated by reference to the detailed description of the invention and the drawings.

## BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 is a representational cross-section of a packaging film of one embodiment of the invention.

Figure 2 is a representational cross-section of a packaging film of another embodiment of the invention.

## DETAILED DESCRIPTION OF THE INVENTION

A packaging film comprises single-walled carbon nanotube ("SWNT") material. The gas transmission rate of the film may be increased by exposing the film to an effective amount of radiation energy.

### Packaging Film

A packaging film is a film that comprises one or more polymers and that is useful as part of a package or packaging system. For example, any of the following may comprise a packaging film: bags, bottles, casings, containers, laminates, lids, liners, pouches, receptacles, trays, tubes, formed or non-formed webs, and wraps.

The packaging film may have any total thickness as long as it provides the desired properties (e.g., flexibility, Young's modulus, optics, strength, barrier) for the given packaging application of expected use. The film may have a thickness of less than about any of the following: 20 mils, 10 mils, 5 mils, 4 mils, 3 mils, 2 mils, 1.5 mils, 1.2 mils, and 1 mil. The film may also have a thickness of at least about any of the following: 0.25 mils, 0.3 mils, 0.35 mils, 0.4 mils, 0.45 mils, 0.5 mils, 0.6 mils, 0.75 mils, 0.8 mils, 0.9 mils, 1 mil, 1.2 mils, 1.4 mils, and 1.5 mils.

The packaging film may be monolayer or multilayer. The film may comprise at least any of the following number of layers: 2, 3, 4, and 5. The film may comprise at most any of the following number of layers: 20, 15, 10, 9, 7, 5, 3, 2, and 1. The term "layer" refers to a discrete film component which is coextensive with the film and has a substantially uniform composition. Any of the layers of the film may have a thickness of at least about any of the following: 0.05, 0.1, 0.2, 0.5, and 1 mil. Any of the layers of the film may have a thickness of at most about any of the following: 5 mils, 2 mils, and 0.5 mils. Any of the layers of the film may

have a thickness as a percentage of the total thickness of the film of at least about any of the following values: 1, 3, 5, 7, 10, 15, and 20 %. Any of the layers of the film may have a thickness as a percentage of the total thickness of the film of at most about any of the following values: 80, 50, 40, 35, and 30 %.

5           The packaging film or a particular layer of the packaging film may have a composition such that any of the below described polymers comprises at least about any of the following weight percent values: 30, 40, 45, 50, 55, 60, 65, 70, 75, 80, 85, 90, 95, 97, 99 and 100% by weight of the film or by weight of a particular layer.

10           The packaging film or any of the particular layers of the packaging film discussed below may be unperforated. As used herein, "unperforated" means that the film (or layer) is substantially devoid of apertures extending through the thickness of the film (or layer). After the radiation energy exposing step discussed below, the packaging film or any of the particular layers of the packaging film discussed below may be perforated (e.g., with a plurality of apertures) or may be unperforated.

#### 15                           Single-Walled Nanotube Material

20           The film comprises single-walled carbon nanotube ("SWNT") material. SWNT material comprises at least one type of SWNTs. SWNT material may comprise any of two, at least two, three, at least three, four, and at least four types of SWNTs. A SWNT comprises a hollow carbon fiber having essentially a single layer of carbon atoms forming the wall of the fiber. A SWNT may be considered as comprising a single-layered graphene sheet. A SWNT comprises a crystalline tubular form of carbon that is related to the C<sub>60</sub> molecules known as "fullerenes." SWNT material may also be referred to as "fullerene pipes" (*see* Science, 1998, vol. 280, page 1254) or "carbon single tubes" (*see* Japanese Unexamined Patent Application, 25   First Publication, No. Hei 8-91816).

          The average diameter of the SWNT material may be at most about any of the following: 50, 40, 30, 20, 10, 5, 3, 2, and 1 nm; and may be at least about any of the following: 0.8, 1, 2, 3, 5, 10, 15, and 20 nm. The ratio of average tube length of SWNT material to the average diameter of the SWNT material may be at least about any of the following: 3, 5, 8, 10,

20, 100, 500, 1,000, 5,000, and 10,000; and may be at most about any of the following: 5, 8, 10, 20, 100, 500, 1,000, 5,000, 10,000, and 20,000.

SWNT material, and methods of making SWNTs, are known in the art. See, for example, U.S. Patents 5,424,054; 5,753,088; 6,063,243; 6,331,209; 6,333,016; 6,413,487; 5 6,426,134; 6,451,175; 6,455,021; 6,517,800; U.S. Patent Publication 2002/0122765 A1; Iijima et al., Nature, Vol. 363, p. 603 (1993); D.S. Bethune et al., Nature 63 (1993) 060; R. Smalley et al, Chem. Phys. Letters, Vol. 243 (1995) 49-54; and Science Vol. 273 (1996) 483-487; each of which is incorporated herein in its entirety by reference.

At least a portion of SWNT material may be functionalized (e.g., derivatized), for example, functionalized with PVOH- or EVOH-containing copolymers. See, for example, Yi 10 Lin et al, "Polymeric Carbon Nanocomposites from Carbon Nanotubes Functionalized with Matrix Polymer," Macromolecules, vol. 36, No. 19, pp. 7199-7204 (August 2003), which is incorporated herein in its entirety by reference. A functionalized SWNT may be chemically bonded to or within one or more chains of a polymer. (See, e.g., U.S. Patent 6,426,134.) For 15 example, a functionalized SWNT may bear a carboxyl group at one end that can serve as a chain-terminating group of a polymer chain, or may bear carboxyl groups at both ends, and through copolymerization may reside at the end of or within a polymer chain. A functionalized SWNT may reside at the end of polymer chains, within the polymer chains, or both.

The SWNT material may be dispersed in the film, for example, so that the SWNT 20 material is evenly dispersed throughout the film. Alternatively, one or more layers of the film may comprise SWNT material (e.g., dispersed in one or more layers of the film), while one or more other layers of the film may be substantially devoid of SWNT material. For example, a barrier layer of the film (discussed below) may comprise SWNT material, or a barrier layer may be substantially devoid of SWNT material. The film may include one or two layers comprising 25 SWNT-material directly adhered to a barrier layer.

The film or a layer of the film (e.g., a barrier layer of the film) may comprise at least about any of the following amounts of SWNT material: 0.001%, 0.005%, 0.01%, 0.05%, 0.1%, 0.5%, 1%, 1.5%, 2%, 2.5%, 3%, 4%, 5%, 8%, 10%, 12%, 15%, 20%, 25%, 30%, 35%, and 40% based on the weight of the film or the weight of a layer incorporating the SWNT 30 material. The film or a layer of the film (e.g., a barrier layer) may comprise at most about any of

the following amounts of SWNT material: 50%, 40%, 30%, 20%, 15%, 10%, 8%, 6%, 5%, 4%, 3%, 2%, 1%, 0.5%, 0.1%, 0.05%, and 0.01% based on the weight of the film or the weight of the layer.

5 In one embodiment, packaging film 10 (Figure 1), which comprises outer layer 12 and one or more other layers 14, may comprise SWNT material by incorporating SWNT in one or more selected regions of the film, such as one or more discontinuous regions 16 supported by the outer layer 12 of film 10, in which case the one or more discontinuous regions 16 may form at least a portion of the outer surface 18 of film 10.

10 In another embodiment, packaging film 20 (Figure 2), which comprises one or more layers 22 and one or more other layers 24, may comprise SWNT material by incorporating SWNT in one or more selected regions of the film, such as one or more discontinuous regions 16 internal to the film structure (e.g., between layers 22 and 24).

15 In either embodiment, the one or more discontinuous regions 16 may comprise any of the percentages of SWNT material mentioned in the previous paragraph (but in relation to the weight of the one or more discontinuous regions). The one or more discontinuous regions 16 may comprise polymer (e.g., thermoplastic polymer), such as one or more of any of the polymers described in this application in any of the percentage amounts described in this application (but in relation to the weight of the one or more discontinuous regions). The one or more discontinuous regions 16 may comprise one or more printing inks or varnishes.

20 The one or more discontinuous regions 16 may be in the shape of a dot, a strip, or other arrangement to form a desired area shape on the surface 18 of the film outer layer 12. The one or more discontinuous regions 16 may be deposited onto the film outer layer, for example, by "printing" (i.e., using a print application method) to apply a mixture comprising polymer resin and SWNT material onto the film outer layer in one or more selected regions. Useful printing  
25 methods for applying the mixture include one or more of printing methods known to those of skill in the art, such as screen, gravure, flexographic, roll, metering rod coating, ink-jet, digital, and toner print techniques.

30 Discontinuous regions 16 that have been deposited on an outer layer may subsequently become internal to the film structure by laminating or otherwise depositing one or more additional film layers over the discontinuous regions that incorporate SWNT. For

example, just as a printed image may be "trap printed" by laminating a film over the printed image, so too can discontinuous regions 16 be trapped by an outer film layer.

The discontinuous regions 16 incorporating SWNT material may take the form of one or more bands (e.g., "stripes" or "lanes") of polymeric resin, as described in U.S. Patent 5,110,530 to Havens, which is incorporated herein in its entirety by reference. Such bands may incorporate the dispersed SWNT rather than or in addition to pigment. Such bands may also be internal or external to the film layer structure.

The packaging film may comprise at least about any of the following amounts of SWNT material: 0.001, 0.005, 0.01, 0.05, 0.1, 0.5, 1, 1.5, 2, 2.5, 3, 4, 5, 8, 10, 12, 15, 20, 25, 30, 35, and 40 weight parts SWNT material per 100 weight parts barrier polymer in the film. The film may comprise at most about any of the following amounts of SWNT material: 50, 40, 30, 20, 15, 10, 8, 6, 5, 4, 3, 2, 1, 0.5, 0.1, 0.05, and 0.01 weight parts SWNT material per 100 weight parts barrier polymer in the film. The forgoing weight ratios of this paragraph may also apply as the weight part of SWNT material to 100 weight parts of one or more of any particular barrier polymers identified below.

A layer of the film (e.g., a barrier layer as discussed below) may comprise at least about any of the following amounts of SWNT material based on the total amount of SWNT material in the packaging film: 50, 60, 70, 80, 90, 95, 99 weight %. A layer of the film comprising any of the foregoing amounts of SWNT material may also have a thickness of at most about any of the following percentages based on the total thickness of the packaging film: 50, 40, 30, 20, 15, 10, and 5%.

A barrier layer (discussed below) and/or a layer comprising SWNT material may be an outer layer of the film. An outer layer may be an "outside layer" of the film (i.e., an outer layer adapted or designed to face to the outside of a package incorporating the film) or an "inside layer" of the film (i.e., an outer layer adapted or designed to face the inside of a package incorporating the film). If the film comprises only one layer, then the one layer may be considered an "outer layer." A barrier layer and/or a layer comprising SWNT material may be an inner or interior layer of the film. An inner or interior layer of the film is between two outer layers of the film.

### Barrier Polymers

The packaging film may comprise one or more barrier polymers. A “barrier polymer” is a polymer that may markedly decrease the transmission rate of a specified gas through a film incorporating the polymer, relative to a comparable film not incorporating the polymer. Thus, the barrier polymer for a specified gas imparts enhanced barrier attributes to the film relative to the specified gas. When the term “barrier polymer” is used in this application without reference to a specified gas, it is understood that the term may be in reference to any of water vapor, oxygen, and/or carbon dioxide gases.

For example, an “oxygen barrier polymer” may markedly decrease the oxygen gas transmission rate through a film incorporating the oxygen barrier polymer, because the oxygen barrier polymer imparts enhanced oxygen barrier attributes to the film. If the barrier polymer is effective for carbon dioxide, then the polymer may be considered a “carbon dioxide barrier polymer.” If the barrier polymer is effective for water vapor, then the barrier polymer may be considered a “water vapor barrier polymer.” A barrier polymer that is effective as a barrier for one type of gas may also be effective as a barrier to one or more other gases. For example, a barrier polymer that is effective for oxygen may also be effective for carbon dioxide, such that the same polymer may be considered an oxygen barrier polymer and a carbon dioxide barrier polymer.

If the packaging film is multilayered, then the one or more layers of the film that incorporate one or more barrier polymers in an amount sufficient to notably decrease the transmission rate of a specified gas through the film may be considered “barrier layers” with respect to the specified gas. If the film is monolayer and incorporates one or more barrier polymers, then the monolayer film itself may be considered a “barrier layer.” For example, if a layer comprises an oxygen barrier polymer, then the layer may be considered an oxygen barrier layer.

The film or a barrier layer of the film may comprise one or more barrier polymers in an amount of at least about any of the following: 50%, 60%, 70%, 80%, 90%, 95%, 97%, 98%, 99%, and 99.5%, based on the weight of the film or the barrier layer, respectively.

The film or a barrier layer may comprise more than one barrier polymer such as a blend of barrier polymers, for example, two barrier polymers, at least two barrier polymers, three



barrier polymers, and at least three barrier polymers. The film or a barrier layer may comprise a first barrier polymer in any of the following amounts (based on the weight of the film or barrier layer): at least about 40%, at least about 50%, at least about 60%, at least about 70%, at least about 80%, at least about 90%, at least about 95%, and the ranges between any of these forgoing values (e.g., from about 60 to about 80%). The film or a barrier layer may comprise a second barrier polymer in any of the following amounts (based on the weight of the film or barrier layer): less than about 60%, less than about 50%, less than about 40%, less than about 30%, less than about 20%, less than about 10%, and less than about 5%, and the ranges between any of these forgoing values (e.g., from about 20 to about 40%). The film or a barrier layer may comprise a third barrier polymer in any of the following amounts (based on the weight of the film or barrier layer): less than about 60%, less than about 50%, less than about 40%, less than about 30%, less than about 20%, less than about 10%, and less than about 5%, and the ranges between any of these forgoing values (e.g., from about 20 to about 40%).

A layer of the packaging film may comprise at least about any of the following amounts of a barrier polymer (e.g., oxygen, carbon dioxide, or water vapor barrier polymer) based on the total amount of that class of barrier polymer (e.g., oxygen, carbon dioxide, or water vapor barrier polymer) in the packaging film: 50, 60, 70, 80, 90, 95, and 99 weight %.

A barrier layer may have a thickness of at least about any of the following: 0.05 mils, 0.1 mils, 0.2 mils, 0.25 mils, 0.3 mils, 0.35 mils, 0.4 mils, 0.45 mils, 0.5 mils, 0.6 mils, 0.75 mils, 0.8 mils, 0.9 mils, 1 mil, 1.2 mils, 1.4 mils, and 1.5 mils. A barrier layer may have a thickness of less than about any of the following: 5 mils, 4 mils, 3 mils, 2 mils, 1.5 mils, 1.2 mils, and 1 mils.

Exemplary oxygen barrier polymers include: ethylene/vinyl alcohol copolymer ("EVOH"), polyvinyl alcohol ("PVOH"), vinylidene chloride polymers ("PVdC"), polyalkylene carbonate, polyester (e.g., PET, PEN), polyacrylonitrile ("PAN"), and polyamide.

### EVOH

Useful ethylene/vinyl alcohol copolymer ("EVOH") may have an ethylene content of about 32%, or at least about any of the following values: 20%, 25%, and 30% by weight.

EVOH may have an ethylene content of at most about any of the following values: 40%, 35%,

and 33% by weight. EVOH may include saponified or hydrolyzed ethylene/vinyl acetate copolymers, such as those having a degree of hydrolysis of at least about any of the following values: 50% and 85%.

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### PVdC

Vinylidene chloride polymer ("PVdC") refers to a vinylidene chloride-containing polymer or copolymer -- that is, a polymer that includes monomer units derived from vinylidene chloride ( $\text{CH}_2 = \text{CCl}_2$ ) and also, optionally, monomer units derived from one or more of vinyl chloride, styrene, vinyl acetate, acrylonitrile, and  $\text{C}_1 - \text{C}_{12}$  alkyl esters of (meth)acrylic acid (e.g., methyl acrylate, butyl acrylate, methyl methacrylate). As used herein, "(meth)acrylic acid" refers to both acrylic acid and/or methacrylic acid; and "(meth)acrylate" refers to both acrylate and methacrylate. Examples of PVdC include one or more of the following: vinylidene chloride homopolymer, vinylidene chloride/vinyl chloride copolymer ("VDC/VC"), vinylidene chloride/methyl acrylate copolymer, vinylidene chloride/ethyl acrylate copolymer, vinylidene chloride/ethyl methacrylate copolymer, vinylidene chloride/methyl methacrylate copolymer, vinylidene chloride/butyl acrylate copolymer, vinylidene chloride/styrene copolymer, vinylidene chloride/acrylonitrile copolymer, and vinylidene chloride/vinyl acetate copolymer.

Useful PVdC includes that having at least about 75, at most about 95, and at most about 98 weight % vinylidene chloride monomer. Useful PVdC (for example, as applied by latex emulsion coating) includes that having at least about any of 5%, 10%, and 15% -- and/or at most about any of 25%, 22%, 20%, and 15 weight % -- comonomer with the vinylidene chloride monomer.

Useful PVdC includes that having a weight-average molecular weight ( $M_w$ ) of at least about any of the following 10,000; 50,000; 80,000; 90,000; 100,000; 111,000; 120,000; 150,000; and 180,000; and at most about any of the following: 180,000, 170,000; 160,000; 150,000; 140,000; 100,000; and 50,000. Useful PVdC also includes that having a viscosity-average molecular weight ( $M_z$ ) of at least about any of the following: 130,000; 150,000; 170,000; 200,000; 250,000; and 300,000; and at most about any of the following: 300,000; 270,000; 250,000; and 240,000.

A oxygen barrier layer that includes PVdC may also include a thermal stabilizer (e.g., a hydrogen chloride scavenger such as epoxidized soybean oil) and a lubricating processing aid (e.g., one or more acrylates).

5 Polyamide

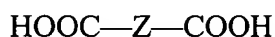
Useful polyamides may include those of the type that may be formed by the polycondensation of one or more diamines with one or more diacids and/or of the type that may be formed by the polycondensation of one or more amino acids. Useful polyamides include aliphatic polyamides and aliphatic/aromatic polyamides.

10 Representative aliphatic diamines for making polyamides include those having the formula:



where n has an integer value of 1 to 16. Representative examples include trimethylenediamine, tetramethylenediamine, pentamethylenediamine, hexamethylenediamine, octamethylenediamine, 15 decamethylenediamine, dodecamethylenediamine, hexadecamethylenediamine. Representative aromatic diamines include p-phenylenediamine, 4,4'-diaminodiphenyl ether, 4,4'-diaminodiphenyl sulphone, 4,4'-diaminodiphenylethane. Representative alkylated diamines include 2,2-dimethylpentamethylenediamine, 2,2,4-trimethylhexamethylenediamine, and 2,4,4-trimethylpentamethylenediamine. Representative cycloaliphatic diamines include 20 diaminodicyclohexylmethane. Other useful diamines include heptamethylenediamine, nonamethylenediamine, and the like.

Representative diacids for making polyamides include dicarboxylic acids, which may be represented by the general formula:



25 where Z is representative of a divalent aliphatic or cyclic radical containing at least 2 carbon atoms. Representative examples include aliphatic dicarboxylic acids, such as adipic acid, sebacic acid, octadecanedioic acid, pimelic acid, suberic acid, azelaic acid, dodecanedioic acid, and glutaric acid; and aromatic dicarboxylic acids, such as isophthalic acid and terephthalic acid.

The polycondensation reaction product of one or more of the above diamines with one or more of the above diacids may form useful polyamides. Representative polyamides of the type that may be formed by the polycondensation of one or more diamines with one or more diacids include aliphatic polyamides such as poly(hexamethylene adipamide) ("nylon-6,6"),  
 5 poly(hexamethylene sebacamide) ("nylon-6,10"), poly(heptamethylene pimelamide) ("nylon-7,7"), poly(octamethylene suberamide) ("nylon-8,8"), poly(hexamethylene azelamide) ("nylon-6,9"), poly(nonamethylene azelamide) ("nylon-9,9"), poly(decamethylene azelamide) ("nylon-10,9"), poly(tetramethylenediamine-co-oxalic acid) ("nylon-4,2"), the polyamide of n-dodecanedioic acid and hexamethylenediamine ("nylon-6,12"), the polyamide of  
 10 dodecamethylenediamine and n-dodecanedioic acid ("nylon-12,12").

	Representative	aliphatic/aromatic	polyamides	include
	poly(tetramethylenediamine-co-isophthalic acid) ("nylon-4,I"), polyhexamethylene isophthalamide ("nylon-6,I"), polyhexamethylene terephthalamide ("nylon-6,T"), poly (2,2,2-trimethyl hexamethylene terephthalamide), poly(m-xylylene adipamide) ("nylon-MXD,6"),			
15	poly(p-xylylene adipamide), poly(hexamethylene terephthalamide), poly(dodecamethylene terephthalamide), and polyamide-MXD,I.			

Representative polyamides of the type that may be formed by the polycondensation of one or more amino acids include poly(4-aminobutyric acid) ("nylon-4"), poly(6-aminohexanoic acid) ("nylon-6" or "poly(caprolactam)"), poly(7-aminoheptanoic acid)  
 20 ("nylon-7"), poly(8-aminooctanoic acid) ("nylon-8"), poly(9-aminononanoic acid) ("nylon-9"), poly(10-aminodecanoic acid) ("nylon-10"), poly(11-aminoundecanoic acid) ("nylon-11"), and poly(12-aminododecanoic acid) ("nylon-12").

Representative copolyamides include copolymers based on a combination of the monomers used to make any of the foregoing polyamides, such as, nylon-4/6, nylon-6/6, nylon-  
 25 6/9, nylon-6/12, caprolactam/hexamethylene adipamide copolymer ("nylon-6,6/6"), hexamethylene adipamide/caprolactam copolymer ("nylon-6/6,6"), trimethylene adipamide/hexamethylene azelaamide copolymer ("nylon-trimethyl 6,2/6,2"), hexamethylene adipamide-hexamethylene-azelaamide caprolactam copolymer ("nylon-6,6/6,9/6"), hexamethylene adipamide/hexamethylene-isophthalamide ("nylon-6,6/6,I"), hexamethylene

adipamide/hexamethyleneterephthalamide (“nylon-6,6/6,T”), nylon-6,T/6,I, nylon-6/MXD,T/MXD,I, nylon-6,6/6,10, and nylon-6,I/6,T.

Conventional nomenclature typically lists the major constituent of a copolymer before the slash (“/”) in the name of a copolymer; however, in this application the constituent listed before the slash is not necessarily the major constituent unless specifically identified as such. For example, unless the application specifically notes to the contrary, “nylon-6/6,6” and “nylon-6,6/6” may be considered as referring to the same type of copolyamide.

Polyamide copolymers may include the most prevalent polymer unit in the copolymer (e.g., hexamethylene adipamide as a polymer unit in the copolymer nylon-6,6/6) in mole percentages ranging from any of the following: at least about 50%, at least about 60%, at least about 70%, at least about 80%, and at least about 90%, and the ranges between any of the forgoing values (e.g., from about 60 to about 80%); and may include the second most prevalent polymer unit in the copolymer (e.g., caprolactam as a polymer unit in the copolymer nylon-6,6/6) in mole percentages ranging from any of the following: less than about 50%, less than about 40%, less than about 30%, less than about 20%, less than about 10%, and the ranges between any of the forgoing values (e.g., from about 20 to about 40%).

Useful polyamides include those that are approved by the controlling regulating agency (e.g., the U.S. Food and Drug Agency) for either direct contact with food and/or for use in a food packaging film, at the desired conditions of use.

### Polyesters

Useful polyesters include those made by: 1) condensation of polyfunctional carboxylic acids with polyfunctional alcohols, 2) polycondensation of hydroxycarboxylic acid, and 3) polymerization of cyclic esters (e.g., lactone).

Exemplary polyfunctional carboxylic acids (and their derivatives such as anhydrides or simple esters like methyl esters) include aromatic dicarboxylic acids and derivatives (e.g., terephthalic acid, isophthalic acid, dimethyl terephthalate, dimethyl isophthalate) and aliphatic dicarboxylic acids and derivatives (e.g., adipic acid, azelaic acid, sebacic acid, oxalic acid, succinic acid, glutaric acid, dodecanoic diacid, 1,4-cyclohexane

dicarboxylic acid, dimethyl-1,4-cyclohexane dicarboxylate ester, dimethyl adipate). Useful dicarboxylic acids also include those discussed above in the polyamide section. As is known to those of skill in the art, polyesters may be produced using anhydrides and esters of polyfunctional carboxylic acids.

5 Exemplary polyfunctional alcohols include dihydric alcohols (and bisphenols) such as ethylene glycol, 1,2- propanediol, 1,3-propanediol, 1,3 butanediol, 1,4-butanediol, 1,4-cyclohexanedimethanol, 2,2-dimethyl-1,3-propanediol, 1,6-hexanediol, poly(tetrahydroxy-1,1'-biphenyl, 1,4-hydroquinone, and bisphenol A.

Exemplary hydroxycarboxylic acids and lactones include 4-hydroxybenzoic acid,  
10 6-hydroxy-2-naphthoic acid, pivalolactone, and caprolactone.

Useful polyesters include homopolymers and copolymers. These may be derived from one or more of the constituents discussed above. Exemplary polyesters include poly(ethylene terephthalate) ("PET"), poly(butylene terephthalate) ("PBT"), and poly(ethylene naphthalate) ("PEN"). If the polyester includes a mer unit derived from terephthalic acid, then  
15 such mer content (mole %) of the diacid of the polyester may be at least about any the following: 70, 75, 80, 85, 90, and 95 %.

The polyester may be thermoplastic. The polyester (e.g., copolyester) of the film may be amorphous, or may be partially crystalline (semi-crystalline), such as with a crystallinity of at least about, or at most about, any of the following weight percentages: 10, 15, 20, 25, 30,  
20 35, 40, and 50 %.

#### Other Polymers

The packaging film may comprise one or more thermoplastic polymers, including polyolefins, polystyrenes, polyurethanes, and ionomers.

25 Useful polyolefins include ethylene homo- and co-polymers and propylene homo- and co-polymers. Ethylene homopolymers include high density polyethylene ("HDPE") and low density polyethylene ("LDPE"). Ethylene copolymers include ethylene/alpha-olefin copolymers ("EAOs"), ethylene/unsaturated ester copolymers, and ethylene/(meth)acrylic acid. ("Copolymer" as used in this application means a polymer derived from two or more types of monomers, and  
30 includes terpolymers, etc.)

EAOs are copolymers of ethylene and one or more alpha-olefins, the copolymer having ethylene as the majority mole-percentage content. The comonomer may include one or more C<sub>3</sub>-C<sub>20</sub> α-olefins, one or more C<sub>4</sub>-C<sub>12</sub> α-olefins, and one or more C<sub>4</sub>-C<sub>8</sub> α-olefins. Useful α-olefins include 1-butene, 1-hexene, 1-octene, and mixtures thereof.

5 EAOs include one or more of the following: 1) medium density polyethylene ("MDPE"), for example having a density of from 0.926 to 0.940 g/cm<sup>3</sup>; 2) linear medium density polyethylene ("LMDPE"), for example having a density of from 0.926 to 0.940 g/cm<sup>3</sup>; 3) linear low density polyethylene ("LLDPE"), for example having a density of from 0.919 to 0.925 g/cm<sup>3</sup>; 4) very-low or ultra-low density polyethylene ("VLDPE" and "ULDPE"), for example having  
10 density below 0.915 g/cm<sup>3</sup>, and 5) homogeneous EAOs. Useful EAOs include those having a density of less than about any of the following: 0.925, 0.922, 0.92, 0.917, 0.915, 0.912, 0.91, 0.907, 0.905, 0.903, 0.9, and 0.898 grams/cubic centimeter. Unless otherwise indicated, all densities herein are measured according to ASTM D1505.

The polyethylene polymers may be either heterogeneous or homogeneous. As is  
15 known in the art, heterogeneous polymers have a relatively wide variation in molecular weight and composition distribution. Heterogeneous polymers may be prepared with, for example, conventional Ziegler-Natta catalysts.

On the other hand, homogeneous polymers are typically prepared using metallocene or other single-site catalysts. Such single-site catalysts typically have only one type of catalytic  
20 site, which is believed to be the basis for the homogeneity of the polymers resulting from the polymerization. Homogeneous polymers are structurally different from heterogeneous polymers in that homogeneous polymers exhibit a relatively even sequencing of comonomers within a chain, a mirroring of sequence distribution in all chains, and a similarity of length of all chains. As a result, homogeneous polymers have relatively narrow molecular weight and composition  
25 distributions. Examples of homogeneous polymers include the metallocene-catalyzed linear homogeneous ethylene/alpha-olefin copolymer resins available from the Exxon Chemical Company (Baytown, TX) under the EXACT trademark, linear homogeneous ethylene/alpha-olefin copolymer resins available from the Mitsui Petrochemical Corporation under the TAFMER trademark, and long-chain branched, metallocene-catalyzed homogeneous

ethylene/alpha-olefin copolymer resins available from the Dow Chemical Company under the AFFINITY trademark.

Another useful ethylene copolymer is ethylene/unsaturated ester copolymer, which is the copolymer of ethylene and one or more unsaturated ester monomers. Useful  
5 unsaturated esters include: 1) vinyl esters of aliphatic carboxylic acids, where the esters have from 4 to 12 carbon atoms, and 2) alkyl esters of acrylic or methacrylic acid (collectively, "alkyl (meth)acrylate"), where the esters have from 4 to 12 carbon atoms.

Representative examples of the first ("vinyl ester") group of monomers include vinyl acetate, vinyl propionate, vinyl hexanoate, and vinyl 2-ethylhexanoate. The vinyl ester  
10 monomer may have from 4 to 8 carbon atoms, from 4 to 6 carbon atoms, from 4 to 5 carbon atoms, and preferably 4 carbon atoms.

Representative examples of the second ("alkyl (meth)acrylate") group of monomers include methyl acrylate, ethyl acrylate, isobutyl acrylate, n-butyl acrylate, hexyl acrylate, and 2-ethylhexyl acrylate, methyl methacrylate, ethyl methacrylate, isobutyl  
15 methacrylate, n-butyl methacrylate, hexyl methacrylate, and 2-ethylhexyl methacrylate. The alkyl (meth)acrylate monomer may have from 4 to 8 carbon atoms, from 4 to 6 carbon atoms, and preferably from 4 to 5 carbon atoms.

The unsaturated ester (i.e., vinyl ester or alkyl (meth)acrylate) comonomer content of the ethylene/unsaturated ester copolymer may range from about 6 to about 18 weight  
20 %, and from about 8 to about 12 weight %, based on the weight of the copolymer. Useful ethylene contents of the ethylene/unsaturated ester copolymer include the following amounts: at least about 82 weight %, at least about 85 weight %, at least about 88 weight %, no greater than about 94 weight %, no greater than about 93 weight %, and no greater than about 92 weight %, based on the weight of the copolymer.

Representative examples of ethylene/unsaturated ester copolymers include ethylene/methyl acrylate, ethylene/methyl methacrylate, ethylene/ethyl acrylate, ethylene/ethyl methacrylate, ethylene/butyl acrylate, ethylene/2-ethylhexyl methacrylate, and ethylene/vinyl acetate.

Another useful ethylene copolymer is ethylene/(meth)acrylic acid, which is the  
30 copolymer of ethylene and acrylic acid, methacrylic acid, or both.





Modified polymers or anhydride-modified polymers include polymers prepared by copolymerizing an unsaturated carboxylic acid (e.g., maleic acid, fumaric acid), or a derivative such as the anhydride, ester, or metal salt of the unsaturated carboxylic acid with -- or otherwise incorporating the same into -- an olefin homopolymer or copolymer. Thus, anhydride-modified polymers have an anhydride functionality achieved by grafting or copolymerization.

#### Additional Layers of the Film

The film may include one or more layers in addition to the one or more barrier layers and/or the one or more layers comprising SWNT material. Such additional layers may include one or more tie layers, one or more heat seal layers, an outside layer, an inside layer, one or more abuse layers, and one or more bulk or core layers. Any of these layers may comprise SWNT material, or may be substantially devoid of SWNT material.

Below are some examples of combinations in which the alphabetical symbols designate the layers. Where the film representation below includes the same letter more than once, each occurrence of the letter may represent the same composition or a different composition within the class that performs a similar function.

C/A/E, C/B/A/E, C/B/A/B/E, C/B/A/B/D/E, C/B/A, C/A, A/E, E/B/A, C/D/B/A, E/A/E, A/B/D/E, C/B/A/B/C, C/B/A/B/E, C/B/A/B/D/E, C/D/B/A/B/E, C/D/B/A/B/D/E, C/B/A/B/C, C/B/A/B/E, C/B/A/B/D/E, C/D/B/A/B/E, C/D/B/A/B/D/E

"A" is a barrier layer, as discussed above.

"B" is a tie layer, as discussed above.

"C" is a heat seal layer (i.e., sealant layer), that is, a layer adapted to facilitate the heat-sealing of the film to itself or to another object, such as a substrate, as is known in the art.

"D" is a core or bulk layer.

"E" is an outside (i.e., abuse or print side) layer.

The C, D, and E layers may comprise one or more of any of the polyolefins, ionomers, polyamides, polyesters, polystyrenes, and polyurethanes described above. The amounts of any of these polymers may be at least about, or at most about, 50, 60, 70, 80, 90, and 95 weight % based either on the weight of the film or a layer of the film comprising the polymer.

### Additives

One or more layers of the film may include one or more additives useful in packaging films, such as, antiblocking agents, slip agents, antifog agents, colorants, pigments, dyes, flavorants, antimicrobial agents, meat preservatives, antioxidants, fillers, radiation stabilizers, and antistatic agents. Such additives, and their effective amounts, are known in the art.

### Modulus of the Film

The packaging film preferably exhibits a Young's modulus sufficient to withstand the expected handling and use conditions. Young's modulus may be measured in accordance with one or more of the following ASTM procedures: D882; D5026-95a; D4065-89, each of which is incorporated herein in its entirety by reference. The packaging film may have a Young's modulus – measured either before and/or after the exposing step discussed below -- of at least about and/or at most about any of the following: 10,000; 15,000; 25,000; 40,000; 70,000; 80,000; 90,000; 100,000; 150,000; 200,000; 250,000; 300,000; and 350,000 pounds/square inch, measured at a temperature of 73°F. Useful ranges for Young's modulus for the film include from about 10,000 to about 300,000 psi, from about 15,000 to about 150,000 psi, and from about 15,000 to about 70,000 psi, measured at a temperature of 212°F.

### Appearance Characteristics of the Film

The packaging film may have low haze characteristics. Haze is a measurement of the transmitted light scattered more than 2.5° from the axis of the incident light. Haze is measured against the outside layer of the film. As previously discussed, the "outside layer" is the outer layer of the film that will be adjacent the area outside of the package comprising the film. Haze is measured according to the method of ASTM D 1003, which is incorporated herein in its entirety by reference. All references to "haze" values in this application are by this standard. The haze of the film – measured either before and/or after the exposing step discussed below -- may be no more than about any of the following values: 30%, 25%, 20%, 15%, 10%, 8%, 5%, and 3%.

The packaging film may have a gloss as measured against the outside layer – measured either before and/or after the exposing step discussed below -- of at least about any of

the following values: 40%, 50%, 60%, 63%, 65%, 70%, 75%, 80%, 85%, 90%, and 95%. These percentages represent the ratio of light reflected from the sample to the original amount of light striking the sample at the designated angle. All references to "gloss" values in this application are in accordance with ASTM D 2457 (60° angle), which is incorporated herein in its entirety by reference.

The packaging film may be transparent (at least in the non-printed regions) so that a packaged article may be visible through the film. "Transparent" means that the film transmits incident light with negligible scattering and little absorption, enabling objects (e.g., the packaged article or print) to be seen clearly through the film under typical viewing conditions (i.e., the expected use conditions of the material). The average transparency (i.e., clarity) of the film – measured either before and/or after the exposing step discussed below -- may be at least about any of the following values: 65%, 70%, 75%, 80%, 85%, and 90%, as measured in accordance with ASTM D1746.

The measurement of optical properties of plastic films, including the measurement of total transmission, haze, clarity, and gloss, is discussed in detail in Pike, LeRoy, "Optical Properties of Packaging Materials," Journal of Plastic Film & Sheeting, vol. 9, no. 3, pp. 173-80 (July 1993), of which pages 173-80 is incorporated herein by reference.

#### Film Orientation

The packaging film may be non-oriented. Alternatively, the film may be oriented in either the machine (i.e., longitudinal), the transverse direction, or in both directions (i.e., biaxially oriented), for example, to enhance the strength, optics, and durability of the film. The film may be oriented in at least one direction by any of the following ratios: at least 2.5:1, from about 2.7:1 to about 10:1, at least 2.8:1, at least 2.9:1, at least 3.0:1, at least 3.1:1, at least 3.2:1, at least 3.3:1, at least 3.4:1, at least 3.5:1, at least 3.6:1, and at least 3.7:1.

The packaging film may be non-heat shrinkable – for example, having a free shrink at 185°F (85°C) in each of the machine (longitudinal) and transverse directions of less than about any of the following: 3%, 1%, and 0.5%. Alternatively, the packaging film may be heat shrinkable, for example having a free shrink at 185°F (85°C) in either of the machine or transverse directions of at least about any of the following: 5%, 10%, 15%, 40%, 50%, 55%, 60%, and 65%.

The free shrink at 185°F (85°C) in either of the machine or transverse directions may also range from about any of the following: 40 to 150%, 50 to 140%, and 60 to 130%. The film may have unequal free shrink in both directions, that is differing free shrink in the machine and transverse directions. The film may not have a heat shrink characteristic in both directions. The free shrink of the film is determined by measuring the percent dimensional change in a 10 cm x 10 cm film specimen when subjected to selected heat (i.e., at a certain temperature exposure) according to ASTM D 2732, which is incorporated herein in its entirety by reference.

As is known in the art, a heat-shrinkable film shrinks upon the application of heat while the film is in an unrestrained state. If the film is restrained from shrinking -- for example by a packaged product around which the film shrinks -- then the tension of the heat-shrinkable film increases upon the application of heat. Accordingly, a heat-shrinkable film that has been exposed to heat so that at least a portion of the film is either reduced in size (unrestrained) or under increased tension (restrained) is considered a heat-shrunk (i.e., heat-contracted) film.

The packaging film may exhibit a shrink tension in at least one direction of any of the following: at least 100 psi, 175 psi, from about 175 to about 500 psi, from about 200 to about 500 psi, from about 225 to about 500 psi, from about 250 to about 500 psi, from about 275 to about 500 psi, from about 300 to about 500 psi, and from about 325 to about 500 psi. Shrink tension is measured at 185°F (85°C) in accordance with ASTM D 2838, which is incorporated herein in its entirety by reference. The shrink tension of the film should be low enough for a given end use and film construction so as not to induce an undesired or premature seal failure or delamination.

The packaging film may be annealed or heat-set to reduce the free shrink either slightly, substantially, or completely; or the film may not be heat set or annealed once stretched in order that the film will have a high level of heat shrinkability.

#### Manufacturing the Film

The packaging film may be manufactured by thermoplastic film-forming processes known in the art. The film may be prepared by extrusion or coextrusion utilizing, for example, a tubular trapped bubble film process or a flat film (i.e., cast film or slit die) process.

The packaging film may also be prepared by applying one or more layers by extrusion coating,

adhesive lamination, extrusion lamination, solvent-borne coating, or by latex coating (e.g., spread out and dried on a substrate). A combination of these processes may also be employed. These processes are known to those of skill in the art.

In forming the resin mixture for the one or more film layers that comprise the SWNT material, the SWNT material may be mixed with polymer before the resin mixture is heated or melted for processing to form the film. This may help to disperse the SWNT in the polymer. Once mixed, the blend can be extruded and processed as discussed above.

#### Optional Energy Treatment

One or more of the thermoplastic layers of the film -- or at least a portion of the entire film -- may be cross-linked, for example, to improve the strength of the film. Cross-linking may be achieved by using chemical additives or by subjecting one or more film layers to one or more energetic radiation treatments -- such as ultraviolet, X-ray, gamma ray, beta ray, and high energy electron beam treatment -- to induce cross-linking between molecules of the irradiated material. Useful radiation dosages include at least about any of the following: 5, 7, 10, 15, 20, 25, 30, 35, 40, 45, and 50 kGy (kiloGray). Useful radiation dosages include less than about any of the following: 150, 130, 120, 110, 100, 90, 80, and 70 kGy. The dosage of the radiation utilized for crosslinking may be achieved by a sufficiently low intensity or over a sufficiently long duration such that the SWNT material is not significantly structurally disrupted (and the OTR of the film is not substantially affected).

It may be desirable to avoid irradiating a film layer comprising PVdC or a film layer comprising SWNT. To that end, substrate layers may be extruded and irradiated, and the PVdC-containing layer and/or the SWNT-containing layer (and subsequent layers) may then be applied to the irradiated substrate, for example, by an extrusion coating process.

All or a portion of one or two surfaces the film may be corona and/or plasma treated to change the surface energy of the film, for example, to increase the ability of print or a food product to adhere to the film. One type of oxidative surface treatment involves bringing the sealant film into the proximity of an O<sub>2</sub>- or N<sub>2</sub>-containing gas (e.g., ambient air) which has been ionized. Exemplary techniques are described in, for example, U.S. Patent Nos. 4,120,716 (Bonet) and 4,879,430 (Hoffman), which are incorporated herein in their entirety by reference.

The packaging film may be treated to have a surface energy of at least about 0.034 J/m<sup>2</sup>, preferably at least about 0.036 J/m<sup>2</sup>, more preferably at least about 0.038 J/m<sup>2</sup>, and most preferably at least about 0.040 J/m<sup>2</sup>.

5

#### Increasing the Gas Transmission Rate of the Packaging Film

The gas transmission rate of the packaging film comprising SWNT material may be increased by exposing the packaging film to an effective amount of radiation energy.

The effective amount of radiation energy may comprise, consist of, or consist essentially of one or more of any of the following: 1) non-ionizing radiation, such as visible  
10 light, infrared light, ultraviolet light (e.g., UVA, UVB, and/or UVC), microwave, and radiowave, and 2) ionizing radiation, such as electron beam irradiation, x-ray irradiation, gamma-ray irradiation, beta-ray irradiation, and terahertz radiation. The effective amount of radiation energy may comprise at least about any of the following amounts – 50%, 60%, 70%, 80%, 90%, and 95% -  
- of any one, or any combination of one or more, of the types of radiation energy previously listed.  
15 For example, the effective amount of radiation energy may comprise at least about 50% non-ionizing energy; the effective amount of non-ionizing radiation energy may comprise at least about 50% visible light energy; or the effective amount of ionizing radiation may comprise at least about 60% electron beam radiation energy.

The radiation energy amount (e.g., the surface dosage for non-ionizing radiation  
20 or the absorbed dosage for ionizing radiation) of the exposing step may be delivered within a duration of at most about any of the following: 30, 25, 20, 15, 10, 9, 8, 7, 6, 5, 4, 3, 2, 1, 0.5, 0.1, 0.05, 0.01, 0.005, and 0.001 seconds; and 500, 150, 130, 110, 100, 90, 80, 70, 60, and 50 microseconds. The radiation energy amount (e.g., the surface dosage or the absorbed dosage) of the exposing step may be delivered within a duration of at least about any of the following: 10,  
25 20, 30, 40, 50, 60, 70, 80, 90, 100, 150, and 500 microseconds; and 0.001, 0.005, 0.01, 0.05, 0.1, 0.5, 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 15, 20, and 25 seconds. The delivery of the radiation amount may be substantially continuous during the duration time period, or may occur in a discontinuous manner over the duration time period, for example by any of at least one, at least two, at least three, and at least four pulses of radiation, such as a series of pulses of radiation.

If multiple pulses of radiation are used, then it may be beneficial for the intervals between the pulses of radiation energy to be short enough so that the multiple pulses may have cumulative effect. An individual pulse of radiation may have a duration of at least about any of the following values: 10, 20, 30, 40, 50, 60, 70, 80, 90, 100, 200, 300, 400, and 500  
5 microseconds. An individual pulse of radiation may have a duration of at most about any of the following values: 900, 700, 500, 300, 150, 130, 110, 100, 90, 80, 70, 60, and 50 microseconds.

The duration discussed above may also be considered a residence time for a portion of the packaging film that is in the exposure zone of a radiation delivery device, for example, where the packaging film is in the form of a continuous web that travels beneath a  
10 radiation delivery device, which may be continuously irradiating that portion of the web that travels through the radiation exposure zone.

For non-ionizing radiation, the effective amount of radiation energy to increase the gas transmission rate of the film may be considered a function of the radiation intensity (i.e., the rate of radiation energy flow per unit area) and the duration of the radiation exposure, to  
15 achieve an effective surface dose (i.e., the radiation energy per unit area at the surface of the packaging film). The relationship between these factors may be illustrated by the following equation: (intensity) x (duration) = surface dose.

The radiation energy exposure step may comprise a non-ionizing radiation intensity (measured at the surface of the packaging film) of at least about any of the following:  
20 10, 30, 50, 80, 100, 150, 200, 250, 300, 400, 500, 800, 1,000, 1,200, 1,500, and 1,800 mW/cm<sup>2</sup>; and at most about any of the following: 2,000, 1,800, 1,500, 1,200, 1,000, 800, 500, 450, 400, 350, 300, 250, 200, 150, and 100 mW/cm<sup>2</sup>. Any of these intensities may occur during one or more pulses of radiation, if the radiation energy is delivered in a discontinuous manner.

Effective amounts of non-ionizing radiation energy (measured at the surface of  
25 the packaging film) of the exposing step delivered during any of the durations discussed above may include at least about any of the following surface doses: 0.01, 0.05, 0.1, 0.5, 1, 5, 10, 20, 50, 100, 500, 1,000, 5,000, 10,000, and 20,000 mJ/cm<sup>2</sup> (i.e., milli-Joules/cm<sup>2</sup>); and may include at most about any of the following surface doses: 0.05, 0.1, 0.5, 1, 5, 10, 20, 50, 100, 500, 1,000, 5,000, 10,000, 20,000, 50,000, and 60,000 mJ/cm<sup>2</sup>.



The effective amount of radiation energy may be substantially devoid of microwave energy in the 2.54 nm wavelength range in order to avoid exciting (heating) water or water-bearing product (e.g., food) that may be enclosed in a package comprising the film.

5 With respect to non-ionizing radiation, the radiation intensity may be measured at the surface of the packaging film utilizing the types of detectors, filters, and radiometers that are correctly calibrated and appropriate for the wavelength ranges of the radiation being measured, as is known to those of skill in the art. See, for example, A. Ryer, "Light Measurement Handbook" (1998, International Light, Inc., Newburyport, MA), which is incorporated herein in its entirety by reference. For example, a silicon detector type may be useful for measuring the  
10 radiation intensity for radiation wavelengths of from about 250 to about 1050 nm, in conjunction with a radiometer such as the IL 1700 (International Light Inc.).

As is also known to those of skill in the art, if a broad range of non-ionizing radiation wavelengths contribute to the radiation being measured, then one or more filters may be used to reduce or eliminate the radiation wavelengths for which a particular detector type is  
15 not appropriate or optimum, and the previously filtered radiation wavelength ranges may be subsequently measured with an appropriate detector while filtering the previously measured radiation wavelengths. The total radiation intensity may be calculated by summing the radiation intensities of the separate measurements of different wavelength ranges.

With respect to ionizing radiation, the effective amount of radiation energy to  
20 increase the gas transmission rate of the film may be characterized as an absorbed dose, which is the amount of energy deposited by ionizing radiation in the packaging film. A common unit of absorbed dose is the kiloGray (kGy), where 1kGy = 1 kJ of energy *absorbed* per kilogram of matter, in this case either per kg of the packaging film comprising SWNT material or per kg of a film layer comprising SWNT material, whichever is specified.

25 Effective amounts of ionizing radiation energy of the exposing step delivered either to the packaging film comprising SWNT material or to the film layer comprising SWNT material, during any of the durations discussed above, may include at least about any of the following absorbed doses: 0.1, 0.5, 1, 2, 5, 10, 15, 20, 30, 50, 100, and 200 kGy; and may include at most about any of the following absorbed doses: 0.5, 1, 2, 5, 10, 15, 20, 30, 50, 100,

200, and 300 kGy. Any of these absorbed dosages may occur during one or more pulses of radiation, if the radiation energy is delivered in a discontinuous manner.

With respect to ionizing radiation, the radiation absorbed dose may be measured utilizing one or more dosimeters and dosimetry techniques that are appropriate for measuring the types and amounts of ionizing radiation energy absorbed by the packaging material incorporating SWNT material or absorbed by the film layer comprising SWNT material, as may be specified. Such dosimeters, dosimetry techniques, and the appropriate calibration methods are known to those of skill in the art. See, for example, ASTM E1261-00 "Standard Guide for Selection and Calibration of Dosimetry Systems for Radiation Processing," which is incorporated herein in its entirety by reference, together with the ASTM standards and reports referenced therein, each of which is incorporated herein in its entirety by reference. See also, as appropriate, the following standard guides and practices from ASTM: E666, E668, E1026, E1204, E1205, E1275, E1276, E1310, E1400, E1401, E1431, E1538, E1539, E1540, E1607, E1608, E1631, E1649, E1650, E1702, E1707, E1818, and E1956, each of which is incorporated herein in its entirety by reference. Additional references include W.L. McLaughlin, "The Measurement of Absorbed Dose and Dose Gradients," *Radiat. Phys. Chem.* Vol. 15, pp. 9-38 (1980) and W.L. McLaughlin et al, "Dosimetry Systems for Radiation Processing," *Radiat. Phys. Chem.* Vol. 46, No.4-6, pp. 1163-74 (1995). As is also known to those of skill in the art, the National Institute of Standards and Technology (NIST) Agency of the U.S. Commerce Department's Technology Administration, 100 Bureau Drive, Stop 8460, Gaithersburg, MD 20899-8460, provides useful calibration services for ionizing radiation dosimetry.

The effective amount of radiation energy of the exposing step may be sufficient to structurally disrupt at least a portion of the SWNT material in the exposed packaging film. The term "structurally disrupt" means structurally or chemically deconstruct or reconstruct (e.g., transform) into another structure or other structures, as for example, by ignition, liberation of adsorbed gas or liquid, burning, thermal energy exposure, temperature increase, or rapid rate of energy conversion. See, for example, P.M. Ajayan et al, "Nanotubes in a Flash – Ignition and Reconstruction," *Science*, vol. 296, p. 705 (April 26, 2002), which is incorporated in its entirety by reference. The radiation exposure step may structurally disrupt at least about any of the following

amounts of SWNT material present in the packaging film: 50, 60, 70, 80, 90, 95, 99, and 100 weight %.

The effective amount of radiation energy of the exposing step may be sufficient to result in the perforation (e.g., with a plurality of apertures) of the packaging film or of one or more layers of the packaging film. It is believed that the radiation energy may cause a rapid heating of the SWNT material, which transfers heat to at least a portion of the packaging film polymer in the vicinity of the SWNT material. Such heat may be generated with sufficient quantity and speed that at least a portion of such polymer may be structurally disrupted, resulting in deconstructed structures that may tend to be liberated from the film or film layer, resulting in the film or one or more film layers being perforated.

After the radiation energy exposing step, the packaging film or any of the particular layers of the packaging film may be perforated or may be unperforated. The exposed packaging film may have any of the gas transmission rates discussed in this application either while the film or one or more layers of the film are perforated or while the film or one or more film layers are unperforated.

Useful equipment, machines, and methods for providing the various types of radiation energy discussed above are known to those of skill in the art, and are therefore not discussed in detail here. For example, the radiation energy may be provided by a photoflash, a flashlamp (e.g., pulsed, gas-filled flashlamps), and spark-gap discharge apparatus. The radiation energy may also be provided by a pulsed lamp system such as those available from Xenon Corp. (Woburn, MA) (e.g., model RC-740, dual lamp and model RC-747 pulsating xenon light) and Maxwell Laboratories, Inc. (e.g., Flashblast Model FB-100 pulsed light system), and those described in U.S. Patents 5,034,235 and 6,449,923.

#### Oxygen Transmission

The packaging film may have an "initial" oxygen transmission rate, that is, the oxygen transmission rate before the radiation energy exposure step, of at most about any of the following values: 1,000, 500, 400, 300, 200, 150, 100, 50, 45, 40, 35, 30, 25, 20, 15, 10, and 5 cubic centimeters (at standard temperature and pressure) per square meter per day per 1 atmosphere of oxygen pressure differential measured at 0% relative humidity and 23°C. All

references to oxygen transmission rate in this application are measured at these conditions according to ASTM D-3985. (A reference to the gas transmission attributes of a film that is a component of a laminate refers to the gas transmission attributes of the film itself, which can be measured by separating the film from the laminate – for example, by using an appropriate solvent to dissolve the adhesive that bonds films together to form a laminate.)

The packaging film may have an oxygen transmission rate after the radiation energy exposure step that is higher than the oxygen transmission rate of the packaging film immediately before the radiation exposure step by at least about any of the following values: 100; 500; 1,000; 3,000; 5,000; 8,000; 10,000; 15,000; 20,000; 25,000; 30,000; 35,000; 40,000; 50,000; 100,000; 200,000; 400,000; 800,000; and 1,000,000 cubic centimeters (at standard temperature and pressure) per square meter per day per 1 atmosphere of oxygen pressure differential measured at 0% relative humidity and 23°C. The packaging film may have an oxygen transmission rate after the radiation exposure step that is higher than the oxygen transmission rate of the packaging film immediately before the radiation exposure step by at most about any of the following values: 3,000; 5,000; 8,000; 10,000; 15,000; 20,000; 25,000; 30,000; 35,000; 40,000; 50,000; 60,000; 70,000; 90,000; 110,000; 200,000; and 400,000 cubic centimeters (at standard temperature and pressure) per square meter per day per 1 atmosphere of oxygen pressure differential measured at 0% relative humidity and 23°C.

The packaging film after the radiation energy exposure step may have an oxygen transmission rate of at least about any of the following values: 100; 500; 1,000; 3,000; 5,000; 8,000; 10,000; 15,000; 20,000; 25,000; 30,000; 35,000; 40,000; 50,000; 100,000; 200,000; 400,000; 800,000; and 1,000,000 cubic centimeters (at standard temperature and pressure) per square meter per day per 1 atmosphere of oxygen pressure differential measured at 0% relative humidity and 23°C. The packaging film after the radiation energy exposure step may have an oxygen transmission rate of at most about any of the following values: 3,000; 5,000; 8,000; 10,000; 15,000; 20,000; 25,000; 30,000; 35,000; 40,000; 50,000; 60,000; 70,000; 90,000; 110,000; 200,000; and 400,000 cubic centimeters (at standard temperature and pressure) per square meter per day per 1 atmosphere of oxygen pressure differential measured at 0% relative humidity and 23°C.

### Carbon Dioxide Transmission

The packaging film may have an “initial” carbon dioxide transmission rate, that is, the carbon dioxide transmission rate before the radiation energy exposure step, of at most about any of the following values: 4,000, 2,000, 1,000, 500, 400, 300, 200, 150, 100, 50, 45, 40, 35, 30, 25, 20, 15, 10, and 5 cubic centimeters (at standard temperature and pressure) per square meter per day per 1 atmosphere of carbon dioxide pressure differential measured at 0% relative humidity and 23°C. All references to carbon dioxide transmission rate in this application are measured at these conditions using methodology analogous to ASTM D-3985, adapted for carbon dioxide rather than oxygen.

The packaging film may have a carbon dioxide transmission rate after the radiation energy exposure step that is higher than the carbon dioxide transmission rate of the packaging film immediately before the radiation exposure step by at least about any of the following values: 100; 500; 1,000; 3,000; 5,000; 8,000; 10,000; 15,000; 20,000; 25,000; 30,000; 35,000; 40,000; 50,000; 100,000; 200,000; 400,000; 800,000; and 1,000,000 cubic centimeters (at standard temperature and pressure) per square meter per day per 1 atmosphere of carbon dioxide pressure differential measured at 0% relative humidity and 23°C. The packaging film may have a carbon dioxide transmission rate after the radiation exposure step that is higher than the carbon dioxide transmission rate of the packaging film immediately before the radiation exposure step by at most about any of the following values: 3,000; 5,000; 8,000; 10,000; 15,000; 20,000; 25,000; 30,000; 35,000; 40,000; 50,000; 60,000; 70,000; 90,000; 110,000; 200,000; and 400,000 cubic centimeters (at standard temperature and pressure) per square meter per day per 1 atmosphere of carbon dioxide pressure differential measured at 0% relative humidity and 23°C.

The packaging film after the radiation energy exposure step may have a carbon dioxide transmission rate of at least about any of the following values: 100; 500; 1,000; 3,000; 5,000; 8,000; 10,000; 15,000; 20,000; 25,000; 30,000; 35,000; 40,000; 50,000; 100,000; 200,000; 400,000; 800,000; and 1,000,000 cubic centimeters (at standard temperature and pressure) per square meter per day per 1 atmosphere of carbon dioxide pressure differential measured at 0% relative humidity and 23°C. The packaging film after the radiation energy exposure step may have a carbon dioxide transmission rate of at most about any of the following values: 3,000; 5,000; 8,000; 10,000; 15,000; 20,000; 25,000; 30,000; 35,000; 40,000; 50,000;

60,000; 70,000; 90,000; 110,000; 200,000; and 400,000 cubic centimeters (at standard temperature and pressure) per square meter per day per 1 atmosphere of carbon dioxide pressure differential measured at 0% relative humidity and 23°C.

5

#### Water Vapor Transmission

The packaging film may have an “initial” water vapor transmission rate, that is, the water vapor transmission rate before the radiation energy exposure step, of at most about any of the following values: 150, 100, 80, 60, 50, 40, 20, 15, 10, 5, 1, and 0.5 grams/100 in<sup>2</sup>.24hours (100% humidity, 23°C) measured according to ASTM F 1249-01 (for values at 20 grams or lower) and ASTM E 96 (for values above 20 grams). All references to water vapor transmission rate in this application are measured at these conditions.

The packaging film may have a water vapor transmission rate after the radiation energy exposure step that is higher than the water vapor transmission rate of the packaging film immediately before the radiation exposure step by at least about any of the following values: 500, 400, 300, 250, 200, 150, 100, 80, 60, 50, 40, 20, 15, 10, and 5 grams/100 in<sup>2</sup>.24hours (100% humidity, 23°C). The packaging film may have a water vapor transmission rate after the radiation exposure step that is higher than the water vapor transmission rate of the packaging film immediately before the radiation exposure step by at most about any of the following values: 1,000, 750, 500, 400, 300, 250, 200, 150, 100, 80, 60, 50, 40, 20, 15, and 10 grams/100 in<sup>2</sup>.24hours (100% humidity, 73°F).

The packaging film after the radiation energy exposure step may have a water vapor transmission rate of at least about any of the following values: 500, 400, 300, 250, 200, 150, 100, 80, 60, 50, 40, 20, 15, 10, and 5 grams/100 in<sup>2</sup>.24hours (100% humidity, 23°C). The packaging film after the radiation energy exposure step may have a water vapor transmission rate of at most about any of the following values: 1,000, 750, 500, 400, 300, 250, 200, 150, 100, 80, 60, 50, 40, 20, 15, and 10. The packaging film after the radiation energy exposure step may have any of the above water vapor transmission rates while also not allowing the transmission of liquid water through the film.

### Use of the Packaging Film

The packaging film may be used in or as part of packaging where it is useful for the enclosed interior space of the package to maintain a modified atmosphere for a desired initial time period, then to allow the enclosed interior space of the package to change (e.g., rapidly change) to an atmosphere approaching ambient air after the initial time period.

For example, the modified atmosphere of the interior space of the package may have a high oxygen, carbon dioxide, or nitrogen content relative to ambient air (e.g., at least about any of the following: 70, 80, 90, 95 volume % oxygen, carbon dioxide, or nitrogen) or a low oxygen content relative to ambient air (e.g., less than about any of 10, 5, 1, 0.5, and 0.05 volume % oxygen). After the desired initial time period, the packaging film of the package may be exposed to the effective amount of radiation energy discussed above to effect an increase in gas permeability of the packaging film. This may result in an increase in the exchange rate of transfer of gas from the interior space of the package (e.g., the modified atmosphere) through the exposed packaging film to the ambient atmosphere – and the transfer rate from the ambient atmosphere to the interior of the package, such that atmosphere of the interior space of the package may approach the gas concentrations of ambient air.

For example, red meat may be packaged within a low-oxygen modified atmosphere in the interior of a package incorporating the packaging film to extend the shelf life of the packaged fresh red meat. The fresh “red” meat packaged in the low-oxygen atmosphere may actually have a purple color. At a desired point (e.g., after the package arrives at a supermarket or other retail outlet), the packaging film of the package may be exposed to the effective amount of radiation energy to increase the permeability of the packaging film. Oxygen from ambient air may transfer to the interior space of the package and cause the meat to “bloom” to a desired red color.

The packaging film may be incorporated into, formed into, or used as part of any of the following: bag, bottle, casing, container, laminate, lid, liner, pouch, receptacle, tray, tubes, formed or non-formed web, and wrap. For example, the packaging film may be used as a liner of a tray or as a lid sealed to a tray. A package comprising the packaging film may be used, for example, to package a liquid product, a solid product, and/or a food product (e.g., ground or processed meat products and fresh red meat products such as poultry, pork, beef, sausage, lamb,

goat, horse, and fish.). Useful package configurations include end-seal bag, side-seal bag, L-seal bag, pouch, and seamed casing (e.g., back-seamed tubes by forming an overlap or fin-type seal).

The following examples are presented for the purpose of further illustrating and explaining the present invention and are not to be taken as limiting in any regard. Unless  
5 otherwise indicated, all parts and percentages are by weight.

### Examples

SWNT material was manufactured by the arc discharge method and subsequently purified. The purified SWNT material was functionalized by esterification of the nanotube-bound carboxylic acids. To do so, *N,N'*-dicyclohexyl carbodiimide (DCC, 400 mg, 1.2 mmol),  
10 4-dimethylamino pyridine (DMAP, 66 mg, 0.3 mmol) and 1-hydroxybenzotriazole (HOBT, 130 mg, 0.6 mmol) were dissolved in dimethyl sulfoxide (DMSO, 15 mL). The purified SWNT material (166 mg) was added to the solution, followed by sonication for 1 hour. Then, a solution of polyvinyl alcohol (PVOH) in DMSO (166 mg/mL, 10 mL) was added, and the mixture was  
15 sonicated for another 24 hours. The dark suspension thus obtained was centrifuged at 7,200 rpm. The supernatant was a dark colored solution of the functionalized SWNT material. Upon the removal of solvent, the black solid sample was first washed thoroughly with acetone. The resulting purified functionalized SWNT material was subsequently solubilized in water.

Polyvinyl alcohol (PVOH) from Dupont under the ELVANOL 50-42 mark  
20 (partially hydrolyzed 87%-89%) was dissolved into the functionalized SWNT material/water solution to form a PVOH-SWNT solution having a total solids content of 6 weight % and a weight ratio of PVOH to SWNT material of 100:1.

### Example 1

The PVOH-SWNT solution described above was cast onto a 2 mil film of propylene-ethylene copolymer (Escorene PP-9302 from ExxonMobil) that had been corona treated to increase wettability. Casting was conducted with a #32 Meyer rod. Multiple passes were made with a drying step between passes. Drying was conducted in a forced air oven held at 60°C for 45 minutes. The final PVOH-SWNT coating thickness was 0.3 mils. The PVOH-SWNT coating was optically transparent. The total film thickness of the resulting Example 1  
30



film was about 2.3 mils.

#### Example 2

5 The PVOH-SWNT solution described above was cast onto a 1 mil polylactic acid (PLA) film from Cargill-Dow to form a PLA film having a 0.3 mil thick PVOH-SWNT coating, using method similar to that used to form Example 1. The PVOH-SWNT coating was optically transparent. The total film thickness of the resulting Example 2 film was about 1.3 mils.

#### Comparison 1

10 Comparison 1 was a 2 mil film of propylene-ethylene copolymer (Escorene PP-9302 from ExxonMobil) that was the same as the propylene-ethylene copolymer film used in making Example 1.

#### Comparison 2

15 PVOH from Dupont under the ELVANOL 50-42 mark (partially hydrolyzed 87%-89%) was dissolved in water to form a solution containing 6 weight % solids. To form the Comparison 2 film, the solution was cast repeatedly onto a corona-treated, 2 mil film of propylene-ethylene copolymer (Escorene PP-9302 from ExxonMobil) to form a film having a 2.3 mil total thickness and a 0.3 mil PVOH-coating.

#### Comparison 3

20 A 1 mil PLA film of the type used in Example 2 was coated with a 0.3 mil PVOH coating using a method similar to that used to form Comparison 2 to form a film having a total thickness of about 1.3 mils.

25 The Example 1 and Comparison 2 films were subjected to a duration of pulsed broadband radiation (wavelengths of 200 nm to 1,000 nm) from a xenon lamp (RC-747 Pulsating xenon light, 4.2-inch spiral lamp from Xenon Corporation, Woburn, MA), 10 pulses/second, at a distance of 38 mm from the film. The Example 2 and Comparison 3 films were exposed to  
30 duration of radiation energy exposure of broadband radiation using the same conditions, but at a

distance of 38mm or 50mm as shown in Table 2. Information from Xenon Corp. shows that the lamp has an intensity of 177 mW/cm<sup>2</sup> measured at the center 1.1 inches (27.94 mm) from the face of the lamp housing window, using the average of three readings each lasting 3.0 seconds. The equipment used for these readings was International Light IL1700 Meter / SED033, "B" filter, QNDS-2, with diffuser.

Subsequent to irradiation, the oxygen transmission rate (OTR) of the Example 1-2 and Comparison 2-3 films were measured according to ASTM D-3985 on an Illinois Instruments 8500 Oxygen Permeability analyzer and reported as cubic centimeters (at standard temperature and pressure) per square meter per day per 1 atmosphere of oxygen pressure differential measured at 0% relative humidity and 23°C. (The test sample size was about 5.5 inches by about 5.5 inches square to result in an about 4.25 inch diameter circle of actual test area for the film.) Also, the oxygen transmission rate of the non-irradiated Comparison 1 film was also evaluated under these conditions. The results are presented in Tables 1 and 2.

Table 1

Film	Description	Duration of UV-pulse exposure (seconds @ 38 mm)	OTR*
Comparison 1	PP	None	3900
Comparison 1	PP	None	3420
Comparison 2	PP w/ PVOH	None	59
Comparison 2	PP w/ PVOH	6	54
Example 1	PP w/ SWNT-PVOH	None	30
Example 1	PP w/ SWNT-PVOH	None	27
Example 1	PP w/ SWNT-PVOH	4	28
Example 1	PP w/ SWNT-PVOH	4	32
Example 1	PP w/ SWNT-PVOH	5	31
Example 1	PP w/ SWNT-PVOH	5	>100,000
Example 1	PP w/ SWNT-PVOH	5	>100,000
Example 1	PP w/ SWNT-PVOH	6	3940
Example 1	PP w/ SWNT-PVOH	6	3860

\*cc (STP)/m<sup>2</sup>.day at 1 atmosphere O<sub>2</sub> differential (0% RH, 23°C).

As shown in Table 1, the oxygen transmission rates of the Example 1 film exposed to six seconds of the pulsed broadband radiation (3940 and 3860 cc/m<sup>2</sup>.day) were much higher than the oxygen transmission rates of the Example 1 films that were not exposed to the broadband radiation (30 and 27 cc/m<sup>2</sup>.day) -- and are similar to the oxygen transmission rates of

the Comparison 1 films, which did not contain the PVOH barrier layer (3900 and 3420 cc/m<sup>2</sup>/day). This result indicates that the exposure of the Example 1 film to the radiation energy in essence effectively eliminated the oxygen barrier attributes provided to the Example 1 film by the barrier layer of PVOH.

5 Also as shown in Table 1, the oxygen transmission rates of the Example 1 film exposed to five seconds of the pulsed broadband radiation (>100,000 cc/m<sup>2</sup>.day) were much higher than the oxygen transmission rates of the Example 1 films that were not exposed to the broadband radiation (30 and 27 cc/m<sup>2</sup>.day) -- and were also much higher than the oxygen transmission rates of the Comparison 1 films, which did not contain a PVOH barrier layer (3900 and 3420 cc/m<sup>2</sup>/day). The Example 1 film (5 second exposure) had a plurality of pinholes (i.e.,  
10 apertures) extending through the thickness of the film, such that the film was effectively perforated to provide an extremely high oxygen transmission rate. This result is particularly surprising and unexpected in that it is believed that the structural disruption of the SWNT material and/or the localized heat generated by the SWNT material not only caused a significant increase in the oxygen transmission rate through the barrier layer of PVOH that incorporated the  
15 SWNT material, but also caused a significant increase in the oxygen transmission rate through the adjacent film layers that did not incorporate SWNT material by creating apertures through the thickness of the entire film that contained SWNT material in only one layer of the film.

Table 2

Film	Description	Duration of UV-pulse exposure (seconds / distance)	OTR*
Comparison 3	PLA	None	1230
Example 2	PLA w/ SWNT-PVOH	None	28
Example 2	PLA w/ SWNT-PVOH	None	31
Example 2	PLA w/ SWNT-PVOH	2 sec / 50 mm	27
Example 2	PLA w/ SWNT-PVOH	2 sec / 38 mm	30
Example 2	PLA w/ SWNT-PVOH	3 sec / 38 mm	27
Example 2	PLA w/ SWNT-PVOH	4 sec / 38 mm	27
Example 2	PLA w/ SWNT-PVOH	5 sec / 50 mm	24
Example 2	PLA w/ SWNT-PVOH	5 sec / 38 mm	30
Example 2	PLA w/ SWNT-PVOH	5 sec / 38 mm	>100,000
Example 2	PLA w/ SWNT-PVOH	6 sec / 38 mm	>100,000

20 \*cc (STP)/m<sup>2</sup>.day at 1 atmosphere O<sub>2</sub> differential (0% RH, 23°C).

As shown in Table 2, the oxygen transmission rate of an Example 2 film exposed to five seconds of the pulsed broadband radiation ( $>100,000$  cc/m<sup>2</sup>.day) and an Example 2 film exposed to six seconds of the pulsed broadband radiation ( $>100,000$  cc/m<sup>2</sup>.day) were much higher than the oxygen transmission rates of the Example 2 films that were not exposed to the broadband radiation (28 and 31 cc/m<sup>2</sup>.day) -- and were also much higher than the oxygen transmission rate of the Comparison 3 film, which does not contain a PVOH barrier layer (1230 cc/m<sup>2</sup>/day). These exposed Example 2 films having the  $>100,000$  cc/m<sup>2</sup>.day oxygen transmission rate had a plurality of pinholes (i.e., apertures) extending through the thickness of the film, such that the film was effectively perforated. This result is particularly surprising and unexpected for the reasons stated above in conjunction with Table 1.

Any numerical ranges recited herein include all values from the lower value to the upper value in increments of one unit provided that there is a separation of at least 2 units between any lower value and any higher value. As an example, if it is stated that the amount of a component or a value of a process variable (e.g., temperature, pressure, time) may range from any of 1 to 90, 20 to 80, or 30 to 70, or be any of at least 1, 20, or 30 and at most 90, 80, or 70, then it is intended that values such as 15 to 85, 22 to 68, 43 to 51, and 30 to 32, as well as at least 15, at least 22, and at most 32, are expressly enumerated in this specification. For values that are less than one, one unit is considered to be 0.0001, 0.001, 0.01 or 0.1 as appropriate. These are only examples of what is specifically intended and all possible combinations of numerical values between the lowest value and the highest value enumerated are to be considered to be expressly stated in this application in a similar manner.

The above descriptions are those of preferred embodiments of the invention. Various alterations and changes can be made without departing from the spirit and broader aspects of the invention as defined in the claims, which are to be interpreted in accordance with the principles of patent law, including the doctrine of equivalents. Except in the claims and the specific examples, or where otherwise expressly indicated, all numerical quantities in this description indicating amounts of material, reaction conditions, use conditions, molecular weights, and/or number of carbon atoms, and the like, are to be understood as modified by the word "about" in describing the broadest scope of the invention. Any reference to an item in the disclosure or to an element in the claim in the singular using the articles "a," "an," "the," or

"said" is not to be construed as limiting the item or element to the singular unless expressly so stated. All references to ASTM tests are to the most recent, currently approved, and published version of the ASTM test identified, as of the priority filing date of this application. Each such published ASTM test method is incorporated herein in its entirety by this reference.